

# Work Order ID 51187

August 6, 2009 2:31:51 PM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 8/17/09 Start Qty: 120.00



Cust Item ID:

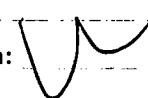
Required Date: 9/04/09 Req'd Qty: 120.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2230	Rev F
-------	-------

100



BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

0.00

0.00

DKL 09/08/12

120 0

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

0.00

DKL 09/08/12

120 0

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

0.00

DKL 09/08/12  
DKL 09/08/13

120 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 51187



Page 2

August 6, 2009 2:31:51 PM

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 8/17/09 Start Qty: 120.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 120.00



Customer:

## Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



## Sequence ID/ Work Center ID

## Operation Description

130



QC

Quality Control

QC8- Inspect parts - second check

## Set Up/ Run Hours

## Draw Number

## Draw Rev.

## Plan Code

## Accept Qty

## Reject Qty

## Reject Number

## Insp. Stamp

0.00

120 Ø

G.A 09/08/15

140



Small Fab

Small Fab

0.00

arh 09/08/15

120 Ø

Small Fab

Memo

0.00

Tumble and deburr rough edges after tumbling

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

M 09/08/16 120 Ø

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 51187**

Page 3

August 6, 2009 2:31:51 PM

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 8/17/09 Start Qty: 120.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 120.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**

160



QC3- Inspect Part Finish

QC

Quality Control

**Set Up/  
Run Hours****Draw  
Number****Draw  
Rev.****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

0.00

0.00

120 accept

J 9-08-17

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 2:45pm OVEN TEMPERATURE:  
FINISH TIME: 3:15pm 320°F

M 09/08/17 X 120

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Am 09 - 08 - 18

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 51187**

Page 4

August 6, 2009 2:31:51 PM

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 8/17/09 Start Qty: 120.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 120.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**

190



Packaging

Packaging

Identify as per dwg & Stock Location: 476Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/08/26 +J

120 BL 09-8-24

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

August 6, 2009 2:31:51 PM

Page 1 / 1

Work Order ID: 51187



Parent Item: D2230-3RevF



Parent Item Name: Lug

Start Date: 8/17/09

Required Date: 9/04/09

Comments:

Start Qty: 120.00

Required Qty: 120.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3RevF		Purchased		No		100	Each	0.0000	120.0000			
LUG												
D2423RevB1		Manufactured		No		100	f	760.9447	8.6274			

Lug Extrusion

Warehouse  
Location

Main Warehouse

ST	760.94468
43722	213.01468
44529	22.39
45800	525.54

Loc Qty

Loc Code

45800

8.700

Wk 09/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	S1187
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

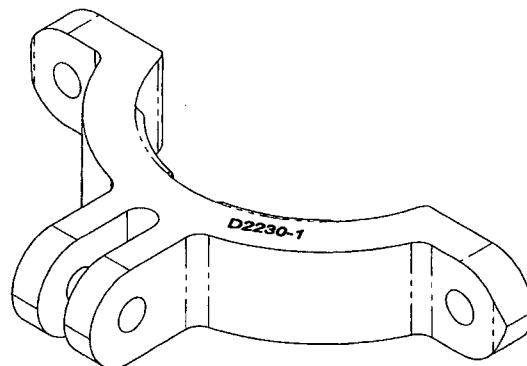
## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/08/12	Date:	09/08/15	Date:	

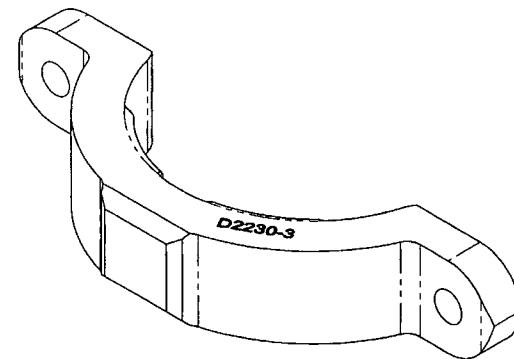
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	[Signature]

8 7 6 5 4 3 2 1

WLD  
SUSY



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED  
07/06/2016



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF  $0.010 \pm 0.005$  IN THIS LOCATION, WITH TOOL TIP RADIUS OF  $0.015 \pm 0.005$ .
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A & B FOR DET. ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.		AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100		CP	99.12.13
E	RE-DESIGN		BW	95.01.04
D	RE-DESIGN		BW	95.01.04
C	RE-DESIGN		BW	94.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	BW	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	A	DRAWING NO.	REV. G	
MFG. APPR.		D2230	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		MOUNTING LUG	NTS	
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8 7 6 5 4 3 2 1

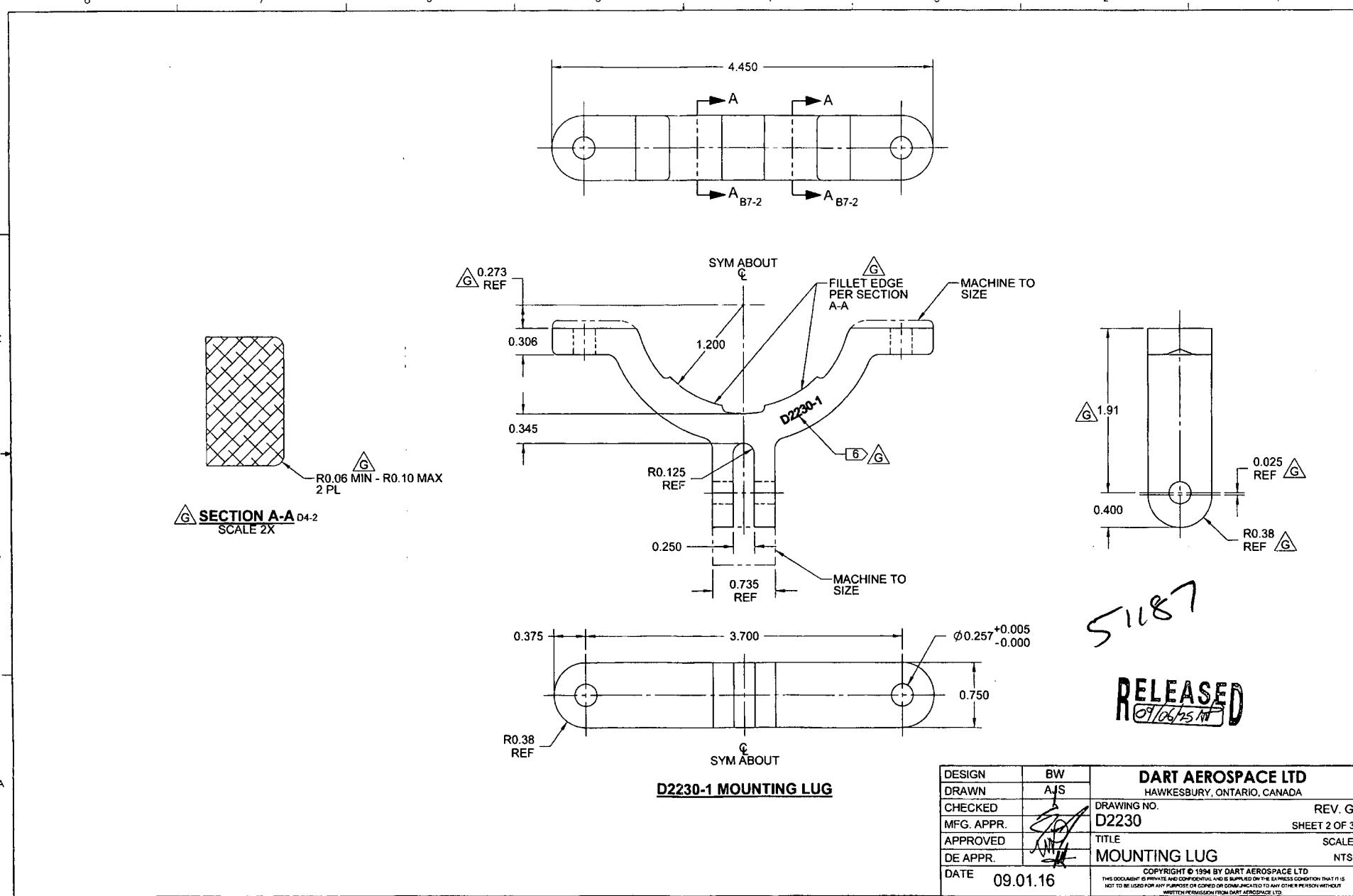
D

C

B

A

1



DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2230 REV. G	
MFG. APPR.		SHEET 2 OF 3	
APPROVED	JW	TITLE MOUNTING LUG	
DE APPR.		SCALE	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION WHICH IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

